

ASAP

Date: Wednesday, 1/31/2007 2:18:48 PM
 User: Kim Johnston

Process Sheet

| | | | | | | |
|-----------------------|--|-----------------------|------------------|---------------|-----|------|
| Customer | : CU-DAR001, Dart Helicopters Services | | Drawing Name | : WEARPLATE | | |
| Job Number | : 30551 | | Part Number | : D25773 | | |
| Estimate Number | : 10298 | | Drawing Number | : D2577 REV E | | |
| P.O. Number | : N/A | | Project Number | : N/A | | |
| This Issue | : 1/31/2007 | S.O. No. : <i>PLA</i> | Drawing Revision | : E | | |
| Prsht Rev. | : NC | | Material | : N/A | | |
| First Issue | : N/A | | Due Date | : 2/12/2007 | | |
| Previous Run | : 29960 | | Qty: | 50 | Um: | Each |
| Written By | | | | | | |
| Checked & Approved By | | | | | | |
| Comment | : Est: F 02.09.24 Re-format; Incorporated D2577-101/-13 K J/RF Est. C 06.07.21 waterjet EC | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|---|--|
| 1.0 | M1010S16GA | 1010/1025/A21/6aA SHEET | |
| | | Comment: Qty.: 1 sf(s)/Unit Total: 46 sf(s) 1010/1025/A21/6aA SHEET 0.063 thick Batch: M103840(50) M101926(1) | |
| 2.0 | WATER JET | FLOW WATER JET | |
| | | Comment: FLOW WATER JET 1-Cut D2577-101 as per Dwg D2577 Dwg Rev: <i>E</i> Prog Rev: <i>E</i> | |
| | | 2-Deburr if necessary | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | |
| 4.0 | QC8 | SECOND CHECK | |
| | | Comment: SECOND CHECK | |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| | | Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/04/09
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|---|---------------------------------|-----------------|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07/04/09 | 2.0 | waterjet miss cut a hole 1st part | <input checked="" type="checkbox"/> QS1042 | Scrap and destroy | SAC 07/04/09 | <input checked="" type="checkbox"/> 07/04/09 | <input checked="" type="checkbox"/> QS1042 | <input checked="" type="checkbox"/> 07/04/09 |
| 07/04/09 | 2.0 | 1 part scrap. hole, was not cut out completely. very bad. | <input checked="" type="checkbox"/> QS1042 | Scrap - destroy | SAC 07/04/09 | <input checked="" type="checkbox"/> 07/04/09 | <input checked="" type="checkbox"/> QS1042 | <input checked="" type="checkbox"/> 07/04/09 |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:18:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 30551

Part Number: D25773

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on brake as per Dwg D2577 using DT8155 and DT8179

2-Identify as D2577-3

MF

07-04-09

(49)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description Batch
A/R 7560 Hardcoat Rod M103794 M103551

FC 07/04/18 (49)

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0 POWDER COATING POWDER COATING



M101601

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

MF

07-04-19 (49)

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



M1-2

07/04/19

(49X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F1P-15

MF

07-04-19

(49)

13.0 QC21 FINAL INSPECTION/W/O RELEASE



KP 07/04/19

(49)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 87.21.20

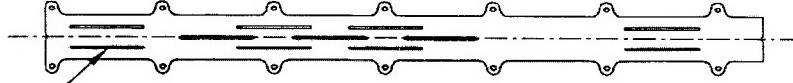
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

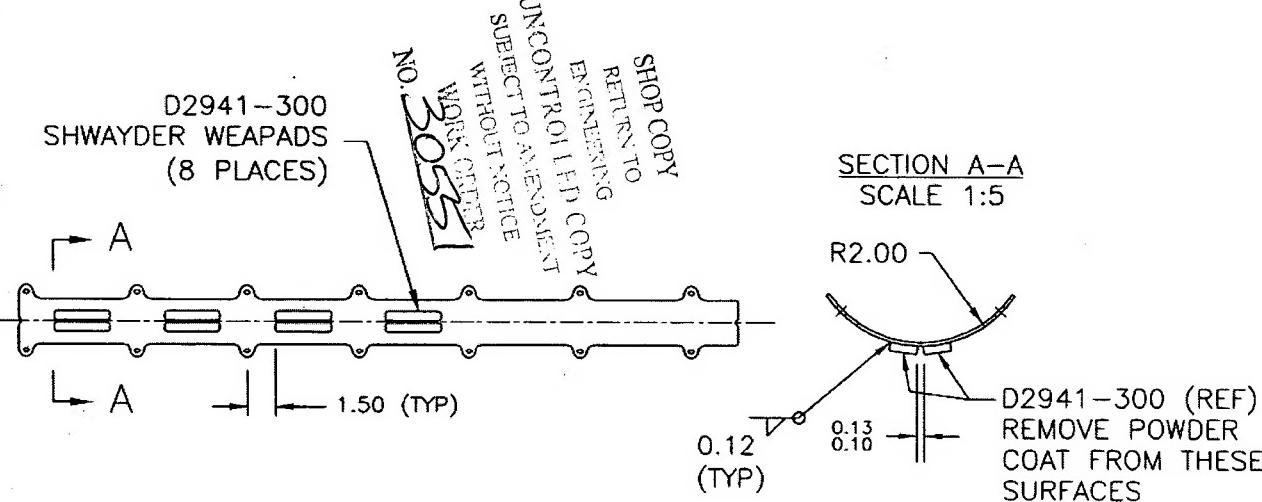
7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D2577-1 & D2577-3 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-21 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

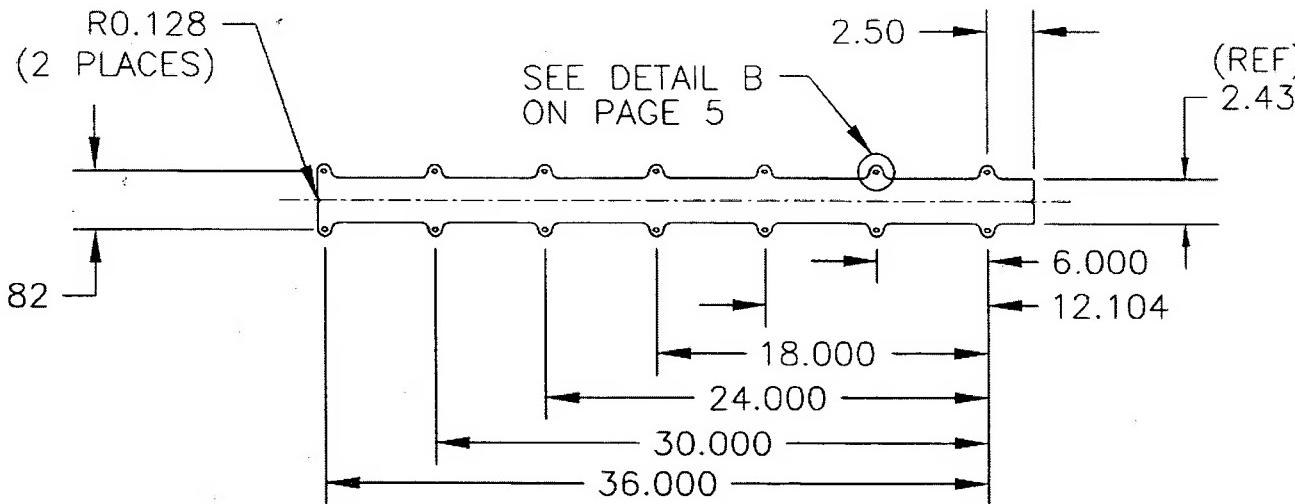
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|---------|----------|--|---------------|
| CHECKED | APPROVED | DRAWING NO. | REV. E |
| DATE | | D2577 | SHEET 1 OF 5 |
| A | 96.09.16 | NEW ISSUE | |
| B | 96.12.04 | ADD HARDCOAT WELDS | |
| C | 97.05.30 | CHANGE HOLES TO OBROUNDS | |
| D | 98.08.17 | CORRECTED DIMENSIONS ON -1 & -3 | |
| E | 00.09.22 | ADD D2577-101/-11/-13 INCORPORATE DE09176 | 1:10 SCALE |

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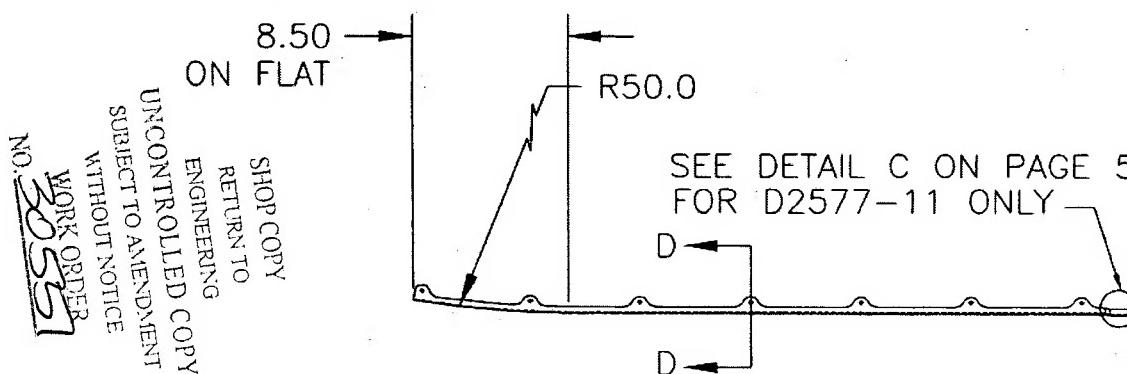


D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

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D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

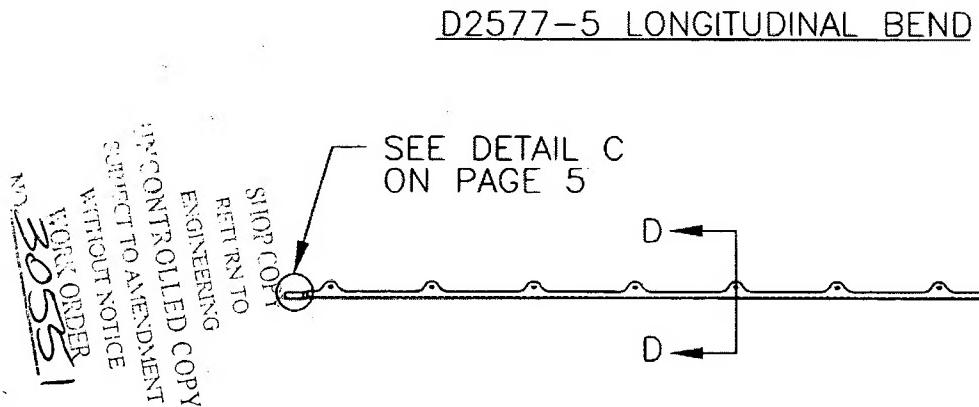
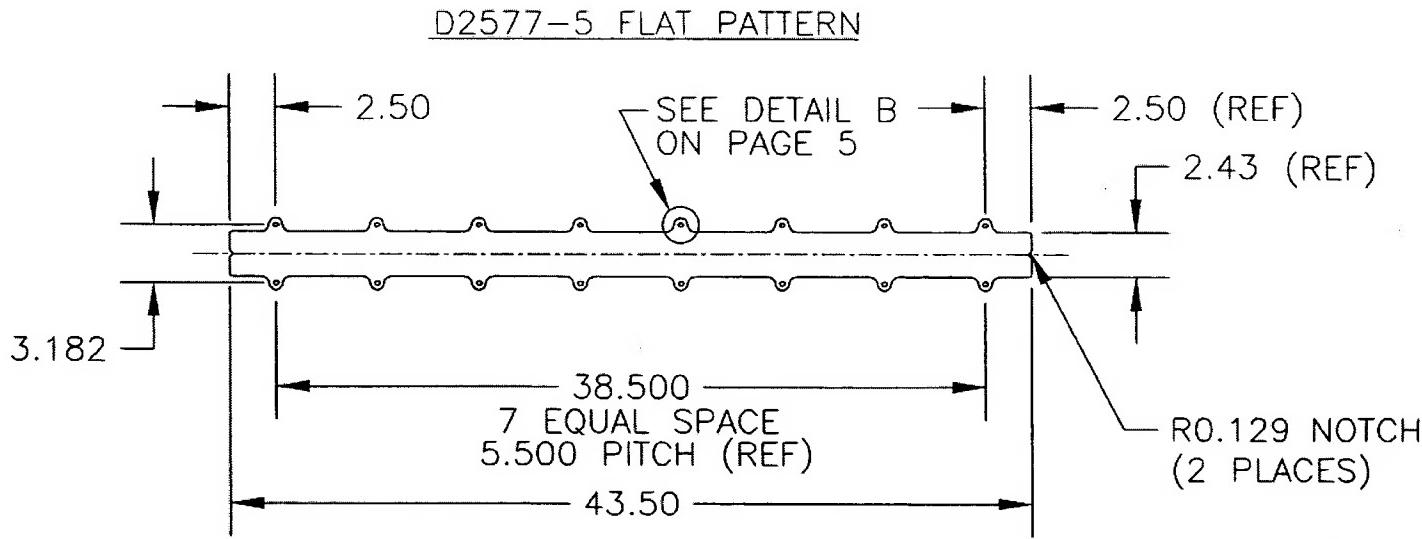
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| DATE | | SHEET 2 OF 5 |
| 00.09.22 | | SCALE 1:10 |
| | | TITLE WEARSHOE |



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
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NO. 30551

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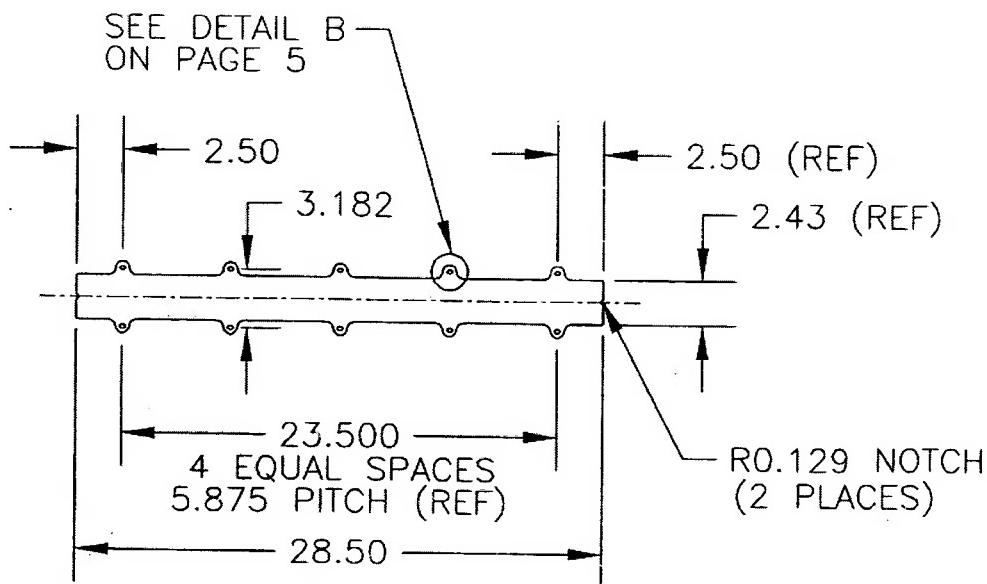


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| DATE 00 09 22 | | TITLE WEARSHOE |

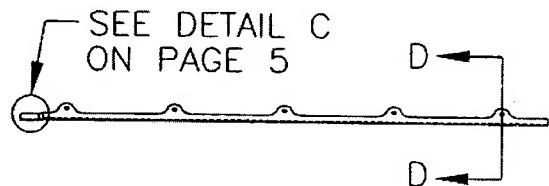
REV. E
SHEET 3 OF 5
SCALE
1:10

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D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
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| CHECKED | APPROVED | DRAWING NO. | SCALE |
| | | D2577 | 1:10 |
| DATE | | TITLE | |
| 00.09.22 | | WEARSHOE | |

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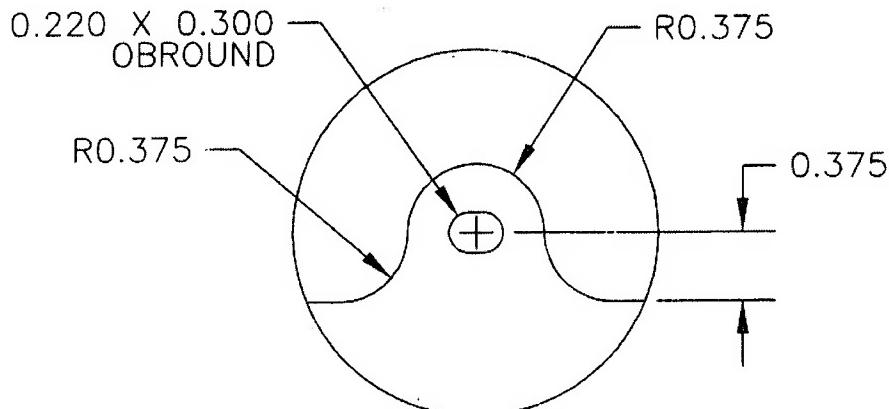


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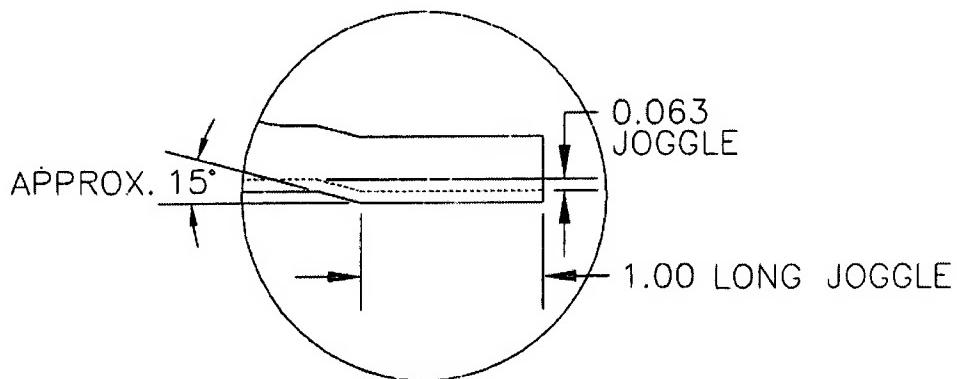
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| 00.09.22 | | TITLE | SCALE |
| | | WEARSHOE | 1:10 |

DETAIL B (SCALE 1:1)

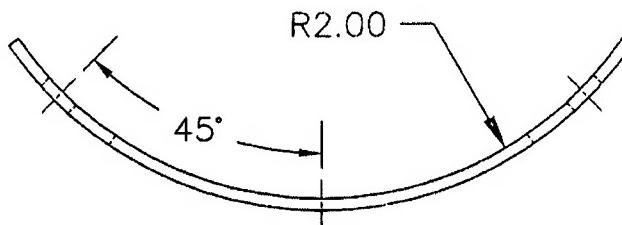
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DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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| | | |
|--------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 30551 |
| Description: | Part Number: | D25773 |
| Inspection Dwg: | Rev: | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------------------------|-----------|------------------|--------|--------|----------------------|----------|
| A 3.182 | +/- 0.010 | 3.186 | ✓ | | Vern | |
| B 36.000 | +/- 0.010 | 36.000 | / | | M-T | |
| C 30.000 | +/- 0.010 | 30.000 | ✓ | | M-T | |
| D 29.000 | +/- 0.010 | 29.000 | / | | M-T | |
| E 18.000 | +/- 0.010 | 18.000 | ✓ | | M-T | |
| F 12.104 | +/- 0.016 | 12.109 | / | | Vern | |
| G 6.000 | +/- 0.010 | 6.001 | ✓ | | Vern | |
| H 2.43 | +/- 0.030 | 2.44 | ✓ | | Vern | |
| I 2.50 | +/- 0.030 | 2.50 | ✓ | | Vertical vern | |
| J 0.220 | +/- 0.010 | 0.217 | ✓ | | Vern | |
| K 0.300 | +/- 0.010 | 0.300 | ✓ | | Vern | |
| L 0.063 | +/- 0.010 | 0.060 | ✓ | | Vern | |
| M | | | | | | |
| N | | | | | | |
| O | | | | | | |
| P | | | | | | |
| Q | | | | | | |
| R | | | | | | |
| S | | | | | | |
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| Y | | | | | | |

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | SAn | Audited by: | Sn | Prototype Approval: | N/A |
| Date: | 07/04/07 | Date: | 07/04/07 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-------------|------------|----------|
| | |) New Issue | KJ/RF | |